

Date: Thursday, 17/04/2008 10:59:11 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 38654		Part Number	: D2572		
Estimate Number	: 10531		Drawing Number	: D2572 REV E		
P.O. Number	:		Project Number	: N/A		
This Issue	: 17/04/2008	S.O. No.	: / /	Drawing Revision	: E	
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 01/05/2008		Qty: 8 Um: Each
Previous Run	: 37922					
Written-By	:					
Checked & Approved By	: <u>JL 08/08/08</u>					
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: <u>1334874</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	 <i>8F 08/08/08</i>
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>8F</u> Double check by: <u>JL</u>	 <i>(PhD) →</i>
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	<i>JP 08/08/08 / 8F 08/08/08</i>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572	<i>JP 08/08/08</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2572 PAR #: NA Fault Category: Prod / Machine Pass NCR: Yes No DQA: S Date: 08/05/12
 QA: N/C Closed: S Date: 08/05/12

NCR: 38654		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/12	# 30	One saddle scrapers due to machinist not tightening the "Y" axis on the manual mill after to doing a fine adjustment.	S	Scrap and destroy and retool replace. Inform senior machinist to recheck all set ups of similar machines Batch 34874	DSF 08/05/12	C	S	C

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

4.0 QC2



INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DR-8/05/08!

5.0 QC8



SECOND CHECK



Comment: SECOND CHECK

SA 08/05/15

6.0 HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

30m.n
15/05/2008

7.0 POWDER COATING



POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

15/05/2008
S.248 11.59

8.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-05-15

#1 318.6
#2 318.6
#3 38654
#4 08/05/2008

9.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 432

AS 08/05/15 X8

10.0 QC21



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/16 X8

Job Completion



MF 08-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38654
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.443	.443	.443	.443		
B	1.745	1.755		1.748	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.747	1.750	1.750	1.750		
E	7.990	8.010		8.000	7.999	7.998	8.002		
F	0.490	0.510		0.498	.502	495	0.496		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		0.499	.502	.503	.505		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.5645	.574	.575	.575		
L	1.174	1.184		1.179	1.179	1.179	1.178		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.873		
P	0.115	0.135		.120	.124	.124	.122		
Q	0.115	0.135		0.135	.135	.135	.135		
R	0.240	0.260		.251	.248	.249	.249		
S	0.115	0.135		0.124	.123	.125	.123		
T	0.178	0.198		-188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.961		
V	0.230	0.250		0.232	.238	.240	.237		
W	0.115	0.135		0.133	.135	0.135	0.126		
X	0.307	0.312		.312	.312	.312	0.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		0.364	.366	.368	0.372		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		0.6215	.625	.625	0.620		
AC	0.053	0.073		0.0625	.062	.062	0.0625		
AD	0.240	0.260		0.244	.250	.250	.251		
AE	1.375	1.395		1.392	1.385	1.384	1.385		
AF	0.115	0.135		0.135	.135	.125	0.125		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		0.243	.249	.249	.250		
AI	2.000	2.020		2.000	2.001	2.003	2.003		
AJ	0.023	0.043		.033	.033				

Accept/Reject

Measured by: SP / DJP
 Date: 08/05/05 / 08/05/06

Audited by: SJ
 Date: 08/05/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<u>SP</u> <u>SJ</u>

DART AEROSPACE LTD	Work Order:	38654
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

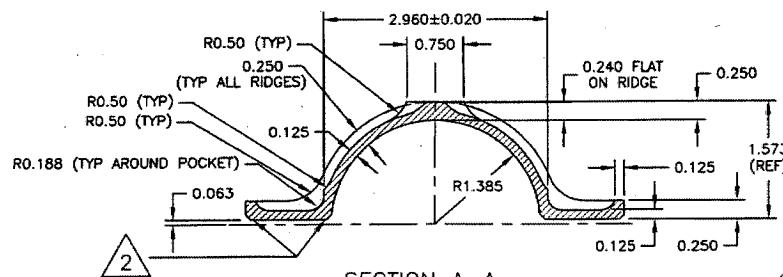
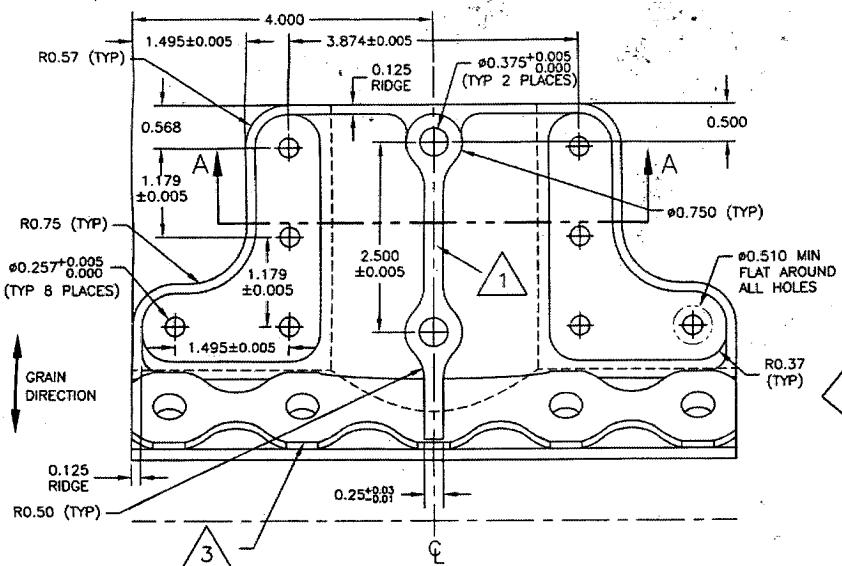
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				ST	6 ⁺	7 ⁻	8 ⁺		
A	0.438	0.443		.443	.443	.443	.443		
B	1.745	1.755		1.748	1.749	1.750	1.750		
C	3.495	3.505		3.501	3.500	3.499	3.499		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.497	0.501	0.5015	0.499		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.378	.375	.376	.376		
I	0.490	0.510		.505	.505	0.502	0.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.575	.575	0.572	0.572		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.491	1.495	1.491		
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O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.123	.122	.123	.122		
Q	0.115	0.135		.135	.135	0.135	0.135		
R	0.240	0.260		.250	.251	.250	.251		
S	0.115	0.135		.122	.125	0.125	0.122		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.962	2.963	2.963	2.962		
V	0.230	0.250		.245	.238	.238	0.230		
W	0.115	0.135		0.125	0.124	0.123	0.123		
X	0.307	0.312							
Y	0.760	0.765							
Z	0.352	0.372		0.370	0.369	0.369	0.362		
AA	0.470	0.530		.502	.500	.500	.500		
AB	0.615	0.635		0.623	0.623	0.623	0.624		
AC	0.053	0.073		0.0625	0.0625	0.0625	0.0625		
AD	0.240	0.260		.250	.250	.250	0.243		
AE	1.375	1.395		1.383	1.383	1.384	1.389		
AF	0.115	0.135		.125	0.135	0.135	0.135		
AG	0.240	0.280		.280	.260	.265	.265		
AH	0.240	0.260		.250	.260	0.246	0.243		
AI	2.000	2.020		2.005	2.005	2.005	2.003		
AJ	0.023	0.043							
Accept/Reject									

Measured by:	8A	Audited by:	SD
Date:	08/05/04	Date:	08/05/14

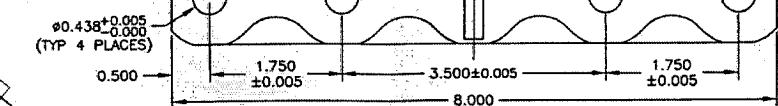
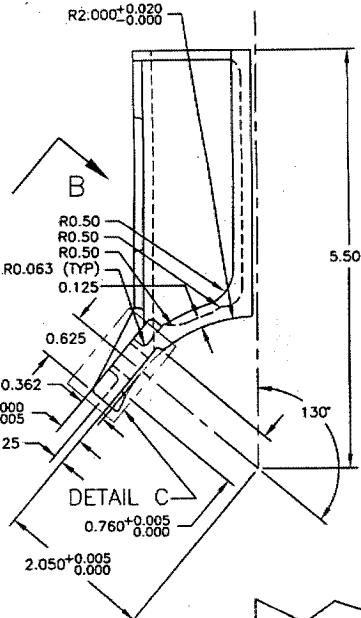
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RELEASED

05.12.06



DETAIL C
SCALE 2:1



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E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DRAWN BY	REV. E
DS	PH	DART
CHECKED	APPROVED	DRAWING NO. D2572
DATE 05.07.13		TITLE INNER FWD SADDLE RETRACTABLE

SHEET 1 OF 1

SHOP COPY

SCALE
2:1

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NO. 38654

